

Work Order ID 114486

114486

Page 1

Thursday, March 06, 2014 1:18:26 PM

Item ID: PB67-43001-343

Accept

N9000040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Tube Arm

Start Date: 3/6/2014 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 3/20/2014 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: mf Date: 14-3-06

Tooling:

Date:

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
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B67-43001	c
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100

0.00

100

Small Fab

Small Fab

Memo

0.00

Small Fab

1- cut
2- bend as per dwg
3- cut to finish size as per dwg
4- deburr

DAS
27
9:59

110

QC5- Inspect part completeness to step on W/O

0.00

110

QC

Memo

0.00

Quality Control

120

Identify as per dwg & Stock Location: Mezz 2 0.00

120

Packaging

Memo

0.00

Packaging

FF
14-04-02

14/4/3

1x 14-4-3 DAS
28
9:59

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%; font-size: small;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Work Order ID 114486

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Thursday, March 06, 2014 1:18:26 PM

Item ID: PB67-43001-343 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Tube Arm
 Start Date: 3/6/2014 Start Qty: 1.00 *1* Cust Item ID:
 Required Date: 3/20/2014 Req'd Qty: 1.00 *1* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	QC21- Final Inspection - Work Order Release	0.00							
130									
QC	Memo	0.00							
Quality Control									

14-04-4
ML5 14-04-03

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

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Picklist Print

Wednesday, April 02, 2014 8:46:35 AM

Page 1

Work Order ID: 114486

114486

Parent Item: PB67-43001-343

PB67-43001-343

Parent Item Name: Tube Arm

Start Date: 3/6/2014

Required Date: 3/20/2014

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A 08-06-26 new issue DD verified by:ec

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M6061T6T1.000W065

Purchased

No

f

87.1700

3.5

M6061T6T1 000W065

6061T6 RD TUBE 1.00 x .065w

FF 14-04-02

Location

Loc Qty

Loc Code

MAT015

87.17

125519

25.17

M126183

2

M128495

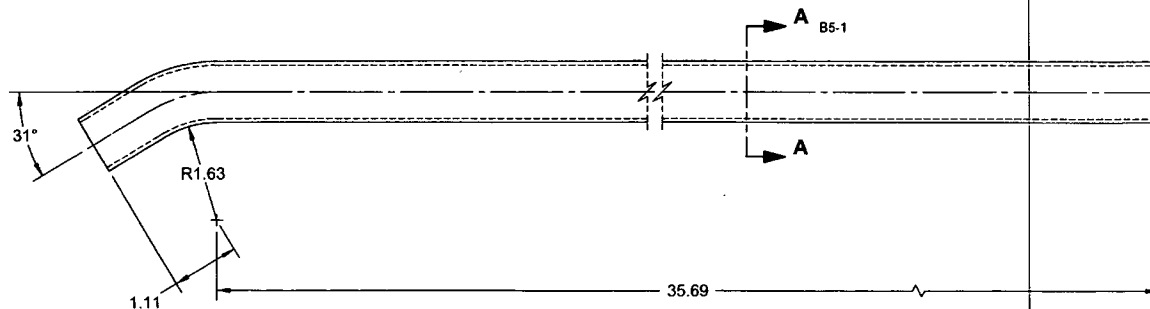
60

3.5

8 7 6 5 4 3 2 1

D

D



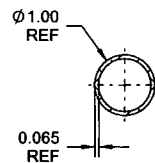
C

C

B67-43001-343 TUBE ARM

B

B



SECTION A-A D5-1

NOTES:

- 1) MATERIAL: 6061-T6 OR 6061-T62 ALUMINUM TUBING
PER WW-T-700/6 OR AMS4080 OR AMS 4082 OR
AMS-QQ-A-200/8 OR AMS-QQ-A-225/8
REF. DART SPEC. M6061T6T0.500W.125
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.71 lbs

A

A

8 7 6 5 4 3 2 1

114486

RELEASED
2009-09-30
JW

C	REDRAWN PREMIER AVIATION DRAWING IAW DART QSI 018 AND QSI 043. FOR PREVIOUS REVISIONS, REFER TO SHEET 34 OF PREMIER AVIATION DRAWING No. B67-43001. REASON: SEE PAR#09-011.		MB	09.02.27	
REV.	DESCRIPTION		BY	DATE	
DESIGN	RW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	REV. C SHEET 1 OF SCALE NTS		
DRAWN					
CHECKED	JJS				DRAWING NO. B67-43001-343
MFG. APPR.	JJS				TITLE
APPROVED	JW				TUBE ARM
DE APPR.	N/A				
DATE	09.02.27	COPYRIGHT © 1995 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			

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